

Work Order ID 149149

Tuesday, July 19, 2016 2:41:09 PM

149149

Page 1

Item ID: D4635-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Ceiling Panel, LH
 Start Date: 7/12/2016 Start Qty: 4.00 *2.00* ***X*** *2.00* ***X*** Cust Item ID:
 Required Date: 7/19/2016 Req'd Qty: 4.00 Customer:
 Reference:

Approvals: Process Plan: **DAS 21** Date: **JUL 20 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: **9-89** Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4635	F

100 0.00 **DAS 07 9-89** *2* *16/07/26*

100 HAND FINISHING THERMOFORMING
 Thermoform Memo 0.08
 Thermoforming Machine Cut Blanks

105 0.00 **DAS 07 9-89** *2* *16/07/26*

105 Dry Material
 HandThermo Memo 0.00
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE

Temp: **245 deg F**
 Time IN: **5:00 PM**
 Time OUT: **6:00 AM**
JUL 25 2016
 Per.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>149149</u> Part No. <u>D4635-3</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☒</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Revision on PFI doesn't match Drawing and w/o				update PFI Rev to match Drawing + w/o.																																																																			
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149149

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

4

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

110

110

Thermoform

Thermoforming Machine

Operation Description

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D4635-3 and Folio FTA149

Dwg. Rev. E I

Folio Rev. k

NOTE: Check moulds prior to using to ensure proper placement of add-ons.
Visually inspect for proper formation and texture

Set Up/ Run Hours

0.00

0.22

Tool ID**Tool #****Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

130

130

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

0.00

0.98

DAS
07
9-89

2

16/08/10.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				7-83	
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 149149

Tuesday, July 19, 2016 2:41:09 PM

149149

Page 3

Item ID: D4635-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Ceiling Panel, LH

Start Date: 7/12/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC6- Inspect dimensions to drawing
Dimensional Inspection

0.00

140

QC

QC2

Memo

0.00

Quality Control

Fill out Inspection Sheet Rev A

16/02/12

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

PPP149162
PPP149161X2 Smb
16/8/13

Pho

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

Quality Control

DAS
21
9-89

AUG 15 2016

DAS
21
9-89

AUG 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

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OTHER : _____																																																																							

Picklist Print

Tuesday, July 19, 2016 2:41:09 PM

Page 1

Work Order ID: 149149

149149

Parent Item: D4635-3

D4635-3

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 7/12/2016

Required Date: 7/19/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev C Dwg. Ulpdate
13/07/09 DL IPP Rev. D Dwg. Update, Material
Change 13/12/18 DL IPP Rev. E Dwg. Update 14/01/09
DL IPP Rev F Dwg, update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	380.9000	9.39	37.56			DAS 07 9-89

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

Location

Loc Qty

Loc Code

MAT023

380.9

m129738

380.9

37.56 sf ft

16/08/13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past-Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

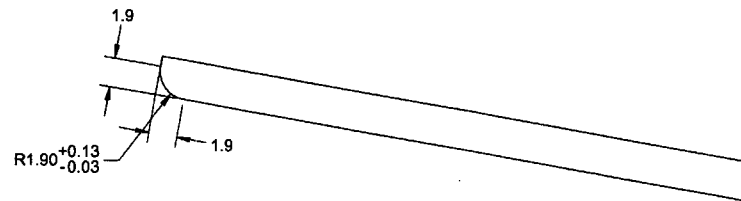
DART AEROSPACE LTD		Work Order: 149149
Description: LH Aft Ceiling Panel		Part Number: D4635-3
Inspection Dwg: D4635	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

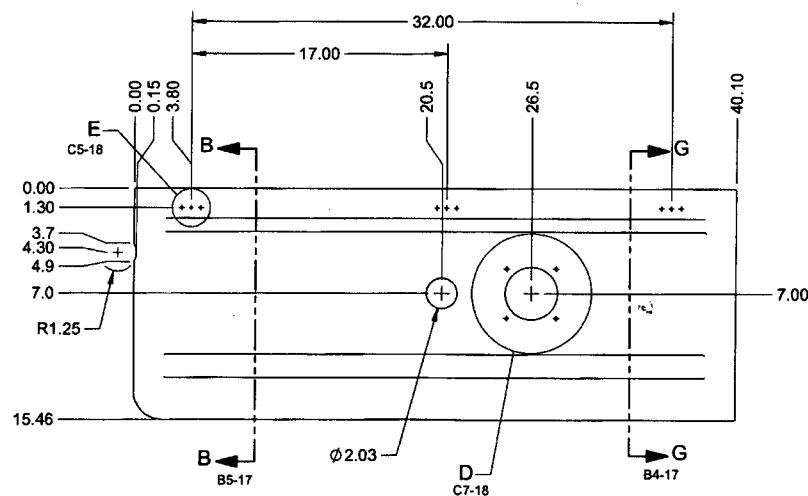
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.80	+/-0.030	3.80 ^u	-		T.M	
17.00	+/-0.030	17.00 ^u	-		T.M	
32.00	+/-0.030	32.00 ^u	-		T.M	
20.5	+/-0.100	20.5 ^u	-		T.M	
26.5	+/-0.100	26.5 ^u	-		T.M	
7.0	+/-0.100	7.0 ^u	-		T.M	
7.0	+/-0.100	7.0 ^u	-		T.M	
Ø2.03	+0.012/-0.001	2.03	-		ED-6	
3.300	+/-0.010	3.307	-		ED-6	
1.650	+/-0.010	1.654	-		ED-6	
3.300	+/-0.010	3.307	-		ED-6	
1.650	+/-0.010	1.654	-		ED-6	
Ø0.191	+0.005/-0.001	0.192	-		ED-6	
1.300	+/-0.010	1.309	-		ED-6	
0.650	+/-0.010	0.655	-		ED-6	
Ø0.129	+0.005/-0.001	0.130	-		ED-6	
0.50	+/-0.030	0.510	-		ED-6	
0.30	+/-0.030	0.32	-		ED-6	
0.35 - 0.40	+/-0.030	0.37	-		ED-6	

Measured by: DAS	Audited by: Smb	Preliminary Approval:
Date: 16/06/12	Date: 16/8/13	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



SECTION H-H B2-15

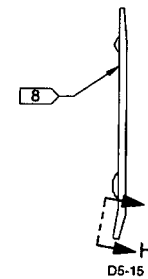


D4635-3 LH, AFT CEILING PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXX.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.66 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

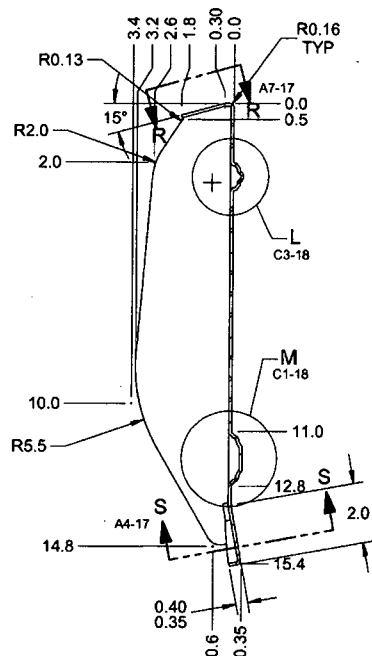
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149149 MWS
16-07-20



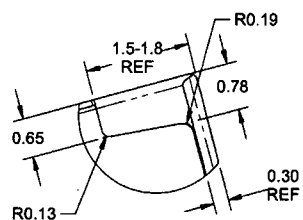
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2015 JAN 26

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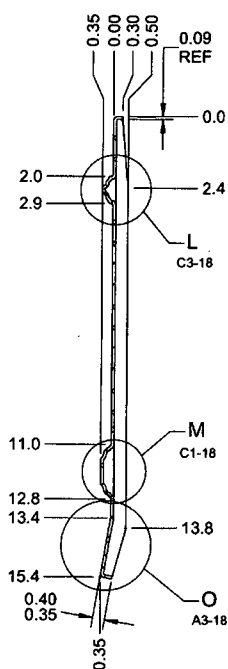
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CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 15 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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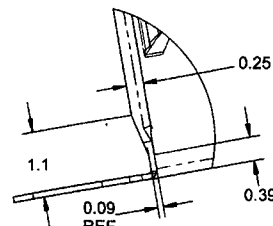
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SECTION A-A' OPPOSITE
SCALE 2X



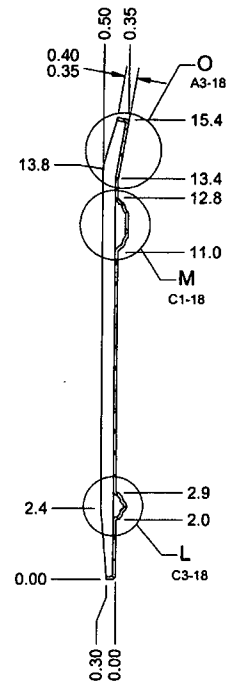
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SECTION R-R' OPPOSITE
SCALE 2X



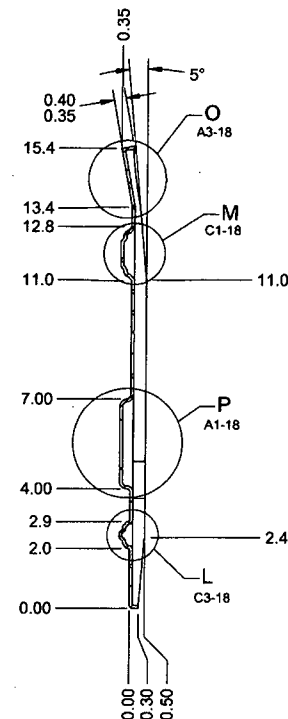
SECTION B-B
SCALE 2X



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X



SECTION G-G
SCALE 2X



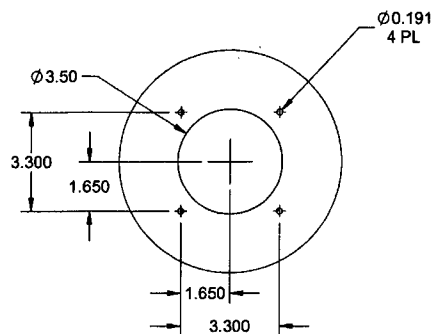
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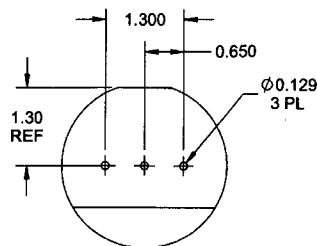
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DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
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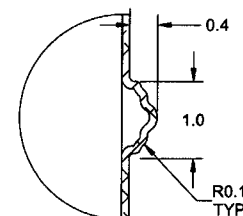
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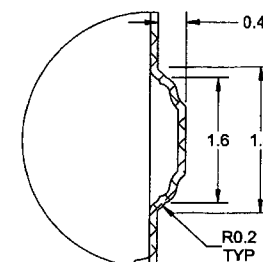
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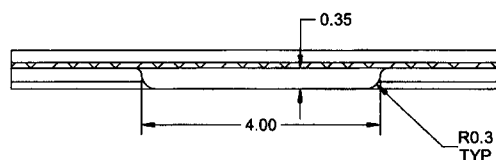
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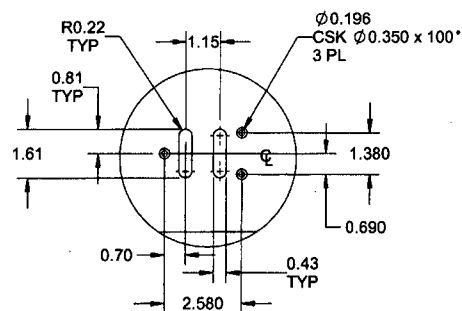
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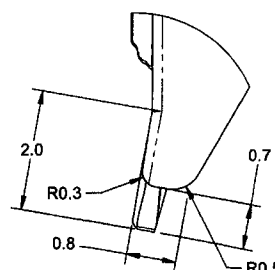
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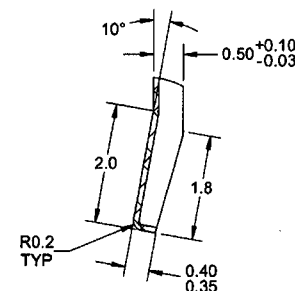
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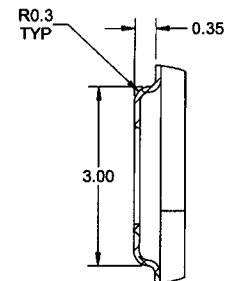
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DETAIL N
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B2-13



DETAIL O
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D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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2015 JAN 26

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 18 OF 18
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8 7 6 5 4 3 2 1